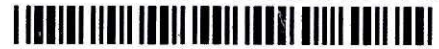




Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-636-011
Job Sheet 177750



Part No: D350-636-011

Job Qty: 1 ea

Part Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/17/18

Job Tracking No:

Due Date: 6/21/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: D2750-041 REV G SHEETS 1,2,4,8 IPP Rev:I 02.09.25 IPP Rev:J 06-03-23 As per Rev D IPP Rev:K 06-07.13
As per dsi9343 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC IPP Rev:M 08-04-22 DD
verified:EC IPP Rev:N 08-09-23 revF DD verified:ec IPP Rev:O 09-02-06 per PAR09-010 DD verf:EC IPP
Rev:P 10.06.22 revise seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH DDverf:EC IPP REV:R
13.08.27 PER ECN13-594 DD VERF:JLM

Ship Via:



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S076919



Part: D350-636-011

Job No: 177750

Serial No/Batch: S076919

Revision:

Inspector:

Exp Date: 05/31/2018

Instructions:

Date: 05/31/18

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	6/21/18	6/21/18	0.00	0.00	Start Up Skid tubes-1		JM
110	Skid tubes	1 pcs	6/21/18	6/21/18	0.00	4.55	Skid tubes-4		BE
120	QC	1 pcs	6/21/18	6/21/18	0.00	0.00	QC10		BE
130	QC	1 pcs	6/21/18	6/21/18	0.00	0.00	QC5		BE
140	HandFinish	1 pcs	6/21/18	6/21/18	0.00	0.93	HandFinish1		SA 18-06-07
150	QC	1 pcs	6/21/18	6/21/18	0.00	0.00	QC7-2		BE
160	Skid tubes	1 pcs	6/21/18	6/21/18	0.00	4.55	Skid tubes-4		DAS
170	QC	1 pcs	6/21/18	6/21/18	0.00	0.00	QC10		DAS 38
180	QC	1 pcs	6/21/18	6/21/18	0.00	0.00	QC5		38 9-88
190	HandFinish	1 pcs	6/21/18	6/21/18	0.00	0.93	HandFinish2		SA 18-06-18
200	SprayPaint	1 pcs	6/21/18	6/21/18	0.00	0.91	Spray Paint		JMD 17/06/2018
205	Outsource	1 pcs	6/21/18	6/21/18			ATE003-VC		
210	QC	1 pcs	6/21/18	6/21/18	0.00	0.00	QC14		18-6-18
230	HandFinish	1 pcs	6/21/18	6/21/18	0.00	0.93	HandFinish4		18-6-18
240	QC	1 pcs	6/21/18	6/21/18	0.00	0.00	QC5		38
250	Packaging	1 pcs	6/21/18	6/21/18	0.00	0.00	Packaging1-3		HUR 2 2018
260	QC	1 pcs	6/21/18	6/21/18	0.00	0.00	QC4		21 2018
265	DC	1 pcs	6/21/18	6/21/18	0.00	0.00	DC		21 2018
270	Packaging	1 pcs	6/21/18	6/21/18	0.00	0.00	Packaging3-1		DAS 21 2018
280	QC21-FG	1 Ea	6/21/18	6/21/18	0.00	0.00	QC21		21 9-88 2018

Part Op 110 - 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg
 Descriptions: D2750-1 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for 2nd side only DT8863B for first side (detail B) 4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 5-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 6- Open up holes of Detail A to 0.297" (total of 2 holes per side) 7-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: 138834 8-Grind welds flush as per Dwg D2750

160 - 1-Open up holes using hole saw of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 2-Open up holes using hole saw of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750. 3- Open float hole using un-bit to 0.500" (4 per side) 4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8) 5-Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 13678 exp. date: 20540262 8-ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D3490-1 D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: 138834 9- At section AJ-AJ drill out x-bolt spacer to 0.404" 10-Grind welds flush as per Dwg D2750 11-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750 12-Deburr holes, ensure tube is free of all scratches before sending to paint.

180 - ***VERIFY C'BOARD IS GOOD***

190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 138747 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 138863

210 - Inspect for foreign object per QSI 024

230 - 1- Install inserts as per Dwg D2750 2-Inspect for Foreign Objects 3- Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: M 138787 EXP DATE: 1812 4- Assemble o-ring to plug as per dwg D3492 and apply o-ring lube A/R 55-o-ring lube batch: M 138757 5- Coat all exposed fasteners with "LPS Procyon" batch: M 138757

260 - *****ensure antiseize is on AN8C21A bolts*****

265 - record fwd angle: 89.9° Photocopy blue file and type labels per PPP D350-636-011 CHG 007

270 - Package as per PPP D350-636-011 Location : FG072

003925

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-LH	Extrusion Bent LH	1 Ea (1 ea)	90-Start up Operation	5073819
D2744	Cap	1 Ea (1 ea)	90-Start up Operation	5063692
D2739	350 I-Beam	1 Ea (1 ea)	160-Skidtubes	5049058
D2743	Crossbolt Spacer	8 Ea (8 ea)	160-Skidtubes	5061803
D3490-1	Cross Bolt Spacer	4 Ea (4 ea)	160-Skidtubes	50658123
D3490-3	Cross Bolt Spacer	4 Ea (4 ea)	160-Skidtubes	5066254
AN3C5A	Bolt	34 Ea (34 ea)	230-HandFinish	5057153
AN3C6A	Bolt	4 Ea (4 ea)	230-HandFinish	5076000
AN6C44A	Bolt	4 Ea (4 ea)	230-HandFinish	FM137055
AN8C35A	Bolt	1 Ea (1 ea)	230-HandFinish	FM137203
D2745	Bushing	8 Ea (8 ea)	230-HandFinish	5053257
D3488-041	Blade Fitting LH	1 Ea (1 ea)	230-HandFinish	5070858
D3492-1 5052900(x3)	Plug	8 Ea (8 ea)	230-HandFinish	507552(x3)
D3492-3 5067025(x1)	Plug	8 Ea (8 ea)	230-HandFinish	507278(x1)
D3535-25	Wearplate Center	1 Ea (1 ea)	230-HandFinish	5072782(x1)
D3536-25	Gasket Center	1 Ea (1 ea)	230-HandFinish	5060747
D3537-1 5045654(x2)	Wearpad	3 Ea (3 ea)	230-HandFinish	5059811
D3631-1	Washer	8 Ea (8 ea)	230-HandFinish	5070788(x1)
D3791-1	Wearpad	1 Ea (1 ea)	230-HandFinish	5058407
D3793-1	Wearplate Fwd	1 Ea (1 ea)	230-HandFinish	5059894
D3793-3	Wearplate Aft	1 Ea (1 ea)	230-HandFinish	5070803
D3794-1	Gasket Fwd	1 Ea (1 ea)	230-HandFinish	5047272
D3794-3	Gasket Aft	1 Ea (1 ea)	230-HandFinish	5059813
MS21043-6	Nut	4 Ea (4 ea)	230-HandFinish	5046513
MS21083C8	Nut	1 Ea (1 ea)	230-HandFinish	5076009
NAS1149C0332R	Washer	38 Ea (38 ea)	230-HandFinish	5034401
NAS1149C0832R	Washer M138405-121	1 Ea (1 ea)	230-HandFinish	5056493
NAS1515H3L	Washer	4 Ea (4 ea)	230-HandFinish	5036714
NAS1611-010	O-Ring	8 Ea (8 ea)	230-HandFinish	5022048
NAS1611-013	O-Ring	8 Ea (8 ea)	230-HandFinish	5034467
ALS4-1032-225	Rivnut	38 Ea (38 ea)	230-HandFinish	5058138
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging	FM137102
D2741	Replacement Blade	1 Ea (1 ea)	250-Packaging	5040882
D3493-1	Washer	2 Ea (2 ea)	250-Packaging	5067105
D3532-1	Spacer	2 Ea (2 ea)	250-Packaging	5062610
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging	5050046
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging	5125635

004044

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-3-BENT-LH	1	2	0
	D2744	1	86	0
160-Skidtubes	D2739	1	10	0
	D2743	8	86	0
	D3490-1	4	128	0
	D3490-3	4	107	0
230-HandFinish	ALS4-1032-225	38	5,405	0
	AN3C5A	34	1,802	0
	AN3C6A	4	266	0
	AN6C44A	4	351	0
	AN8C35A	1	47	0
	D2745	8	113	0
	D3488-041	1	16	0
	D3492-1	8	88	0
	D3492-3	8	87	0
	D3535-25	1	24	0
	D3536-25	1	31	0
	D3537-1	3	169	0
	D3631-1	8	931	0
	D3791-1	1	36	0
	D3793-1	1	30	0
	D3793-3	1	29	0
	D3794-1	1	55	0
	D3794-3	1	29	0
	MS21043-6	4	200	0
	MS21083C8	1	125	0
	NAS1149C0332R	38	7,418	0
	NAS1149C0832R	1	66	0
	NAS1515H3L	4	199	0
	NAS1611-010	8	569	0
	NAS1611-013	8	365	0
250-Packaging	AN8C21A	2	96	0
	D2741	1	87	0
	D3493-1	2	57	0
	D3532-1	2	40	0
	MS21083C8	2	125	0
	NAS1149D0863J	2	119	0
Part Specifications				
Specifications could not be found.				

Plex 5/17/18 12:19 PM Dart.Gagnon.Michelle

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1			D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C8A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

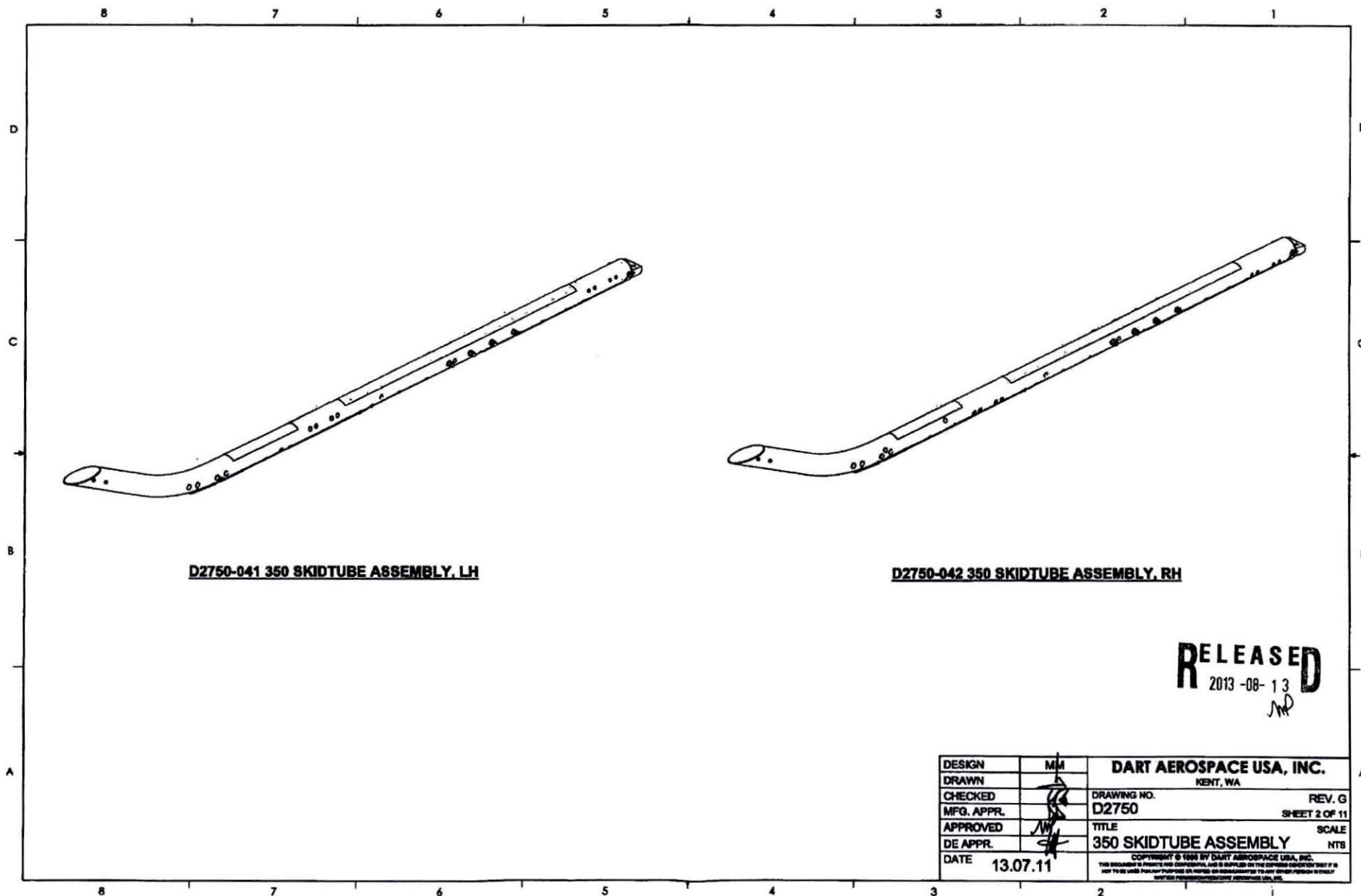
GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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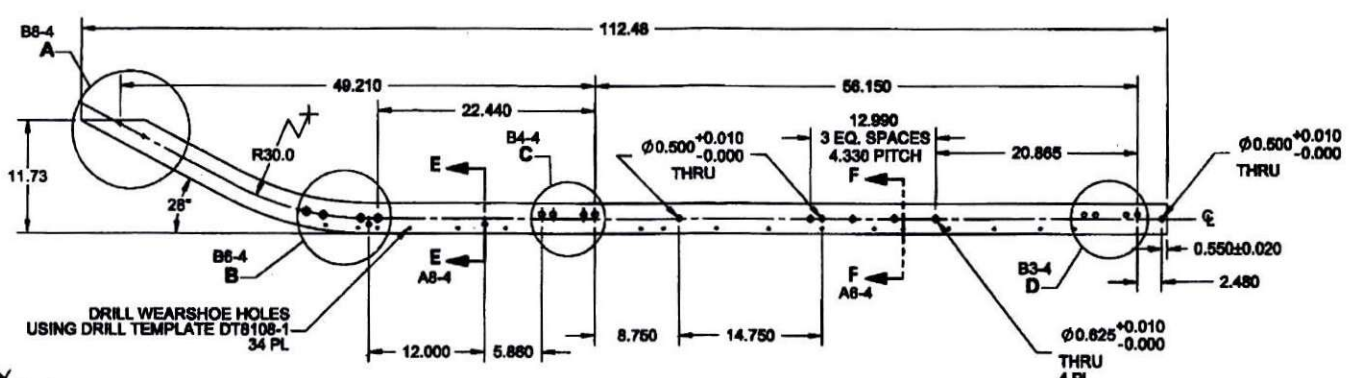
G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS $+0.010/-0.000$, WAS $+0.100/-0.000$ (ZN B3-4, B2-5); ADD VIEW TO CONTROL, FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PARTS-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DS18413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H3L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	06.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	06.09.01
A	NEW ISSUE	DS	06.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		
DART AEROSPACE USA, INC. KENT, WA			
DRAWING NO. D2750 TITLE 350 SKIDTUBE ASSEMBLY			
REV. G SHEET 1 OF 11 SCALE NTS			
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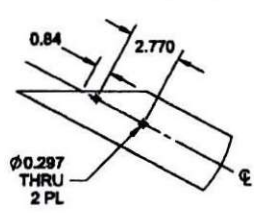
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DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 2 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 1999 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	

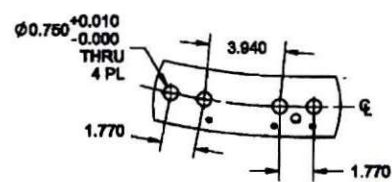
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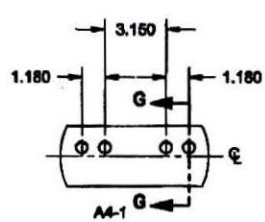
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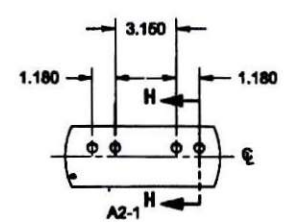
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SCALE 2X



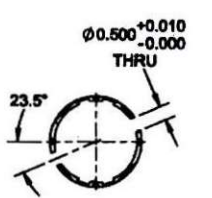
DETAIL B
SCALE 2X



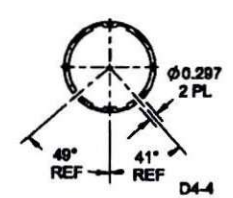
DETAIL C
SCALE 2X



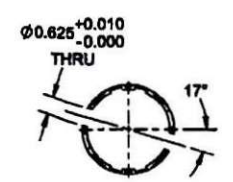
DETAIL D
SCALE 2X



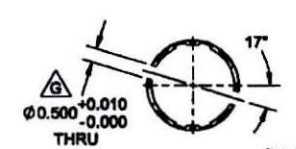
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

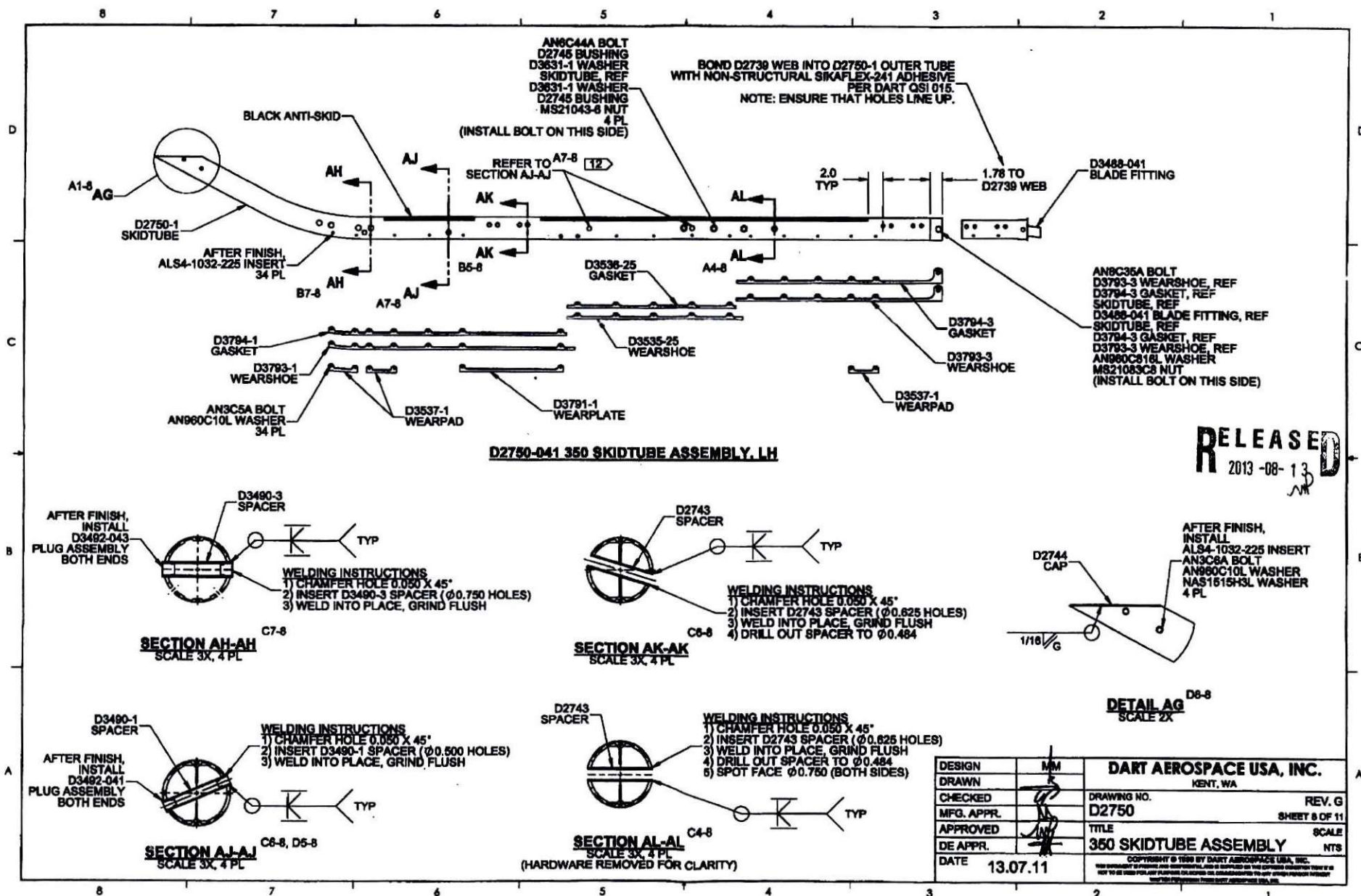


**MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)**

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DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1



PAGE 1 OF 1

Description: SKIDTUBE STD LH/RH, FLOAT COMPATIBLE

[illegible]